

# Work Order ID 68065

Wednesday, April 06, 2011 8:21:01 AM



Page 1

Item ID: D407-667-105TRN

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Turning Detail

Start Date: 4/6/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/18/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *[Signature]*

Date: 11-04-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D407-667-145	Rev C

100

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8673 on both ends as per Folio FA249□2-Turn first side as per Folio FA249□3- File transition lines smooth.

*an 11/05/04*

1 *[Signature]*

110

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

*an 11/05/04*

1 *[Signature]*

120

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA249□2- File transition lines smooth.□3- Remove sand and plugs□4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-145 □Inside of Cuff(Do not engrave on outside of tube)

*an 11/05/05*

1 *[Signature]*

030

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 68065**

Wednesday, April 06, 2011 8:21:02 AM

Page 2

Item ID: D407-667-105TRN

Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Turning Detail

Start Date: 4/6/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 4/18/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC1- Inspect dimensions to dimension sheet

0.00



QC

Memo

0.00

Quality Control

GRK 11/05/05

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

SL 11/05/05

①

150

Crosstubes Chemical Conversion

0.00



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

SAD  
11-05-05

②

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, April 06, 2011 8:20:12 AM

Page 1

Work Order ID: ~~68064~~ 68065

Parent Item: D407-667-105TRN

Parent Item Name: Crosstube Turning Detail



Start Date: 4/6/2011

Start Qty: 1.00

Required Date: 4/18/2011

Required Qty: 1.00

Comments: IPP Rev:a 08.02.28 new issue EC  
IPP Rev B 08.04.02 Removed polish EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6010-115		Manufactured	No			110	Each	37.0000	1	1			



Crosstube Material

Location

LG

38343

Loc Qty

37

37

Loc Code

1 m.L 2011/05/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	68065
<b>Description:</b> Crosstube Assembly	<b>Part Number:</b>	D407-667-145
<b>Inspection Dwg:</b> D407-667-145 Rev: C		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.244	✓		vern ML-7	
	1.865	+0.005/-0.000	1.870	✓		vern ML-7	
	1.878	+0.005/-0.000	1.882	✓		11	
	1.970	+0.005/-0.000	1.973	✓		11	
	2.030	+0.005/-0.000	2.034	✓		11	
	2.165	+0.005/-0.000	2.170	✓		micr cnc-04	
	0.125	+/-0.010	0.127	✓		vern ML-7	
	R0.063	+/-0.010	0.063	✓		RG	
	R0.500	+/-0.010	0.500	✓		RG	
	R0.063	+/-0.010	0.063	✓		RG	
	4.438	+/-0.030	4.449	✓		vern ML-7	
SIDE B	2.240	+0.005/-0.000	2.245	✓		vern ML-7	
	1.865	+0.005/-0.000	1.870	✓		11	
	1.878	+0.005/-0.000	1.883	✓		11	
	1.970	+0.005/-0.000	1.974	✓		11	
	2.030	+0.005/-0.000	2.035	✓		11	
	2.165	+0.005/-0.000	2.170	✓		micr cnc-04	
	0.125	+/-0.010	0.127	✓		vern ML-7	
	R0.063	+/-0.010	0.063	✓		RG	
	R0.500	+/-0.010	0.500	✓		RG	
	R0.063	+/-0.010	0.063	✓		RG	
	4.438	+/-0.030	4.438	✓		vern ML-7	
	113.20	+/-0.020	113.280	✓		Tap ML-2	

<b>Measured by:</b>	<i>[Signature]</i>	<b>Audited by:</b>	<i>[Signature]</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	11/05/05	<b>Date:</b>	11/05/05	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.21	New Issue (P/O D407-667-105)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	09.06.11	Dwg Rev updated	KJ	<i>[Signature]</i>

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Item	Qty -145	Part Number	Description
1	X	D407-667-145	CROSSTUBE ASSEMBLY (407 HIGH FWD)
2	1	D6010-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

# **GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURED FROM D6010-115  
FINISHED LENGTH = 113.20±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D407-667-145" AND BATCH NUMBER ON  
INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 17.8 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,  
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE  
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER  
QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE  
THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS  
ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE  
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS  
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT  
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN  
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 68045

*PL 11-04-6*

**RELEASED**  
08/11/12

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. 7 ADD TOLERANCES (ZN C6-3, C4-3, D2-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	02.05.08
REV	DESCRIPTION	BY	DATE
DESIGN	<i>RF</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>RF</i>	DRAWING NO.	REV. C
CHECKED	<i>RF</i>	D407-667-145	SHEET 1 OF 4
MFG. APPR.	<i>RF</i>	TITLE	SCALE
APPROVED	<i>RF</i>	CROSSTUBE ASSY (407 HIGH FWD)	NTS
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DATE	08.11.06		

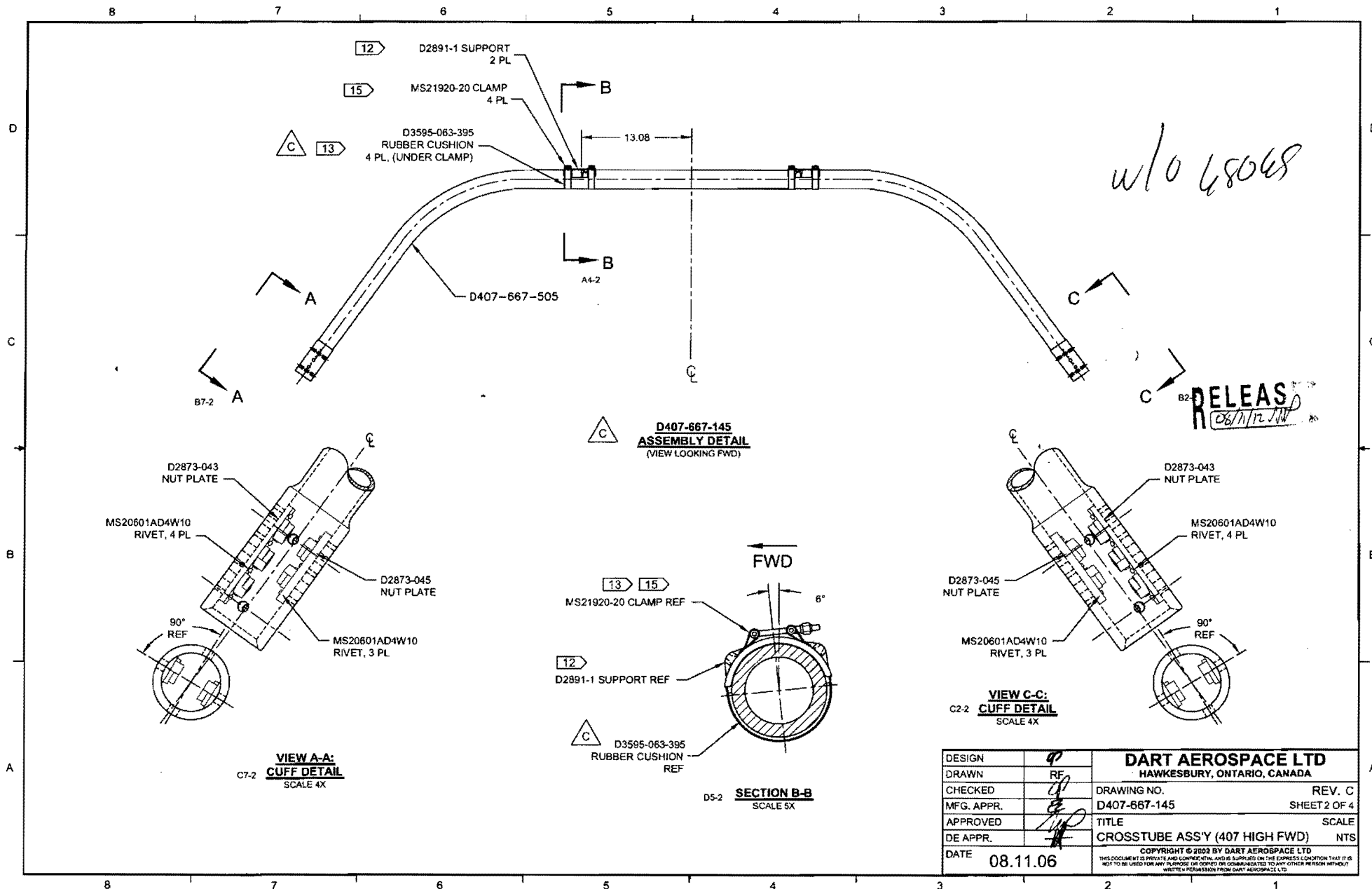
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DESIGN	9	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	9	DRAWING NO.	REV. C
MFG. APPR.	9	D407-667-145	SHEET 2 OF 4
APPROVED	9	TITLE	SCALE
DE APPR.	9	CROSSTUBE ASS'Y (407 HIGH FWD)	NTS
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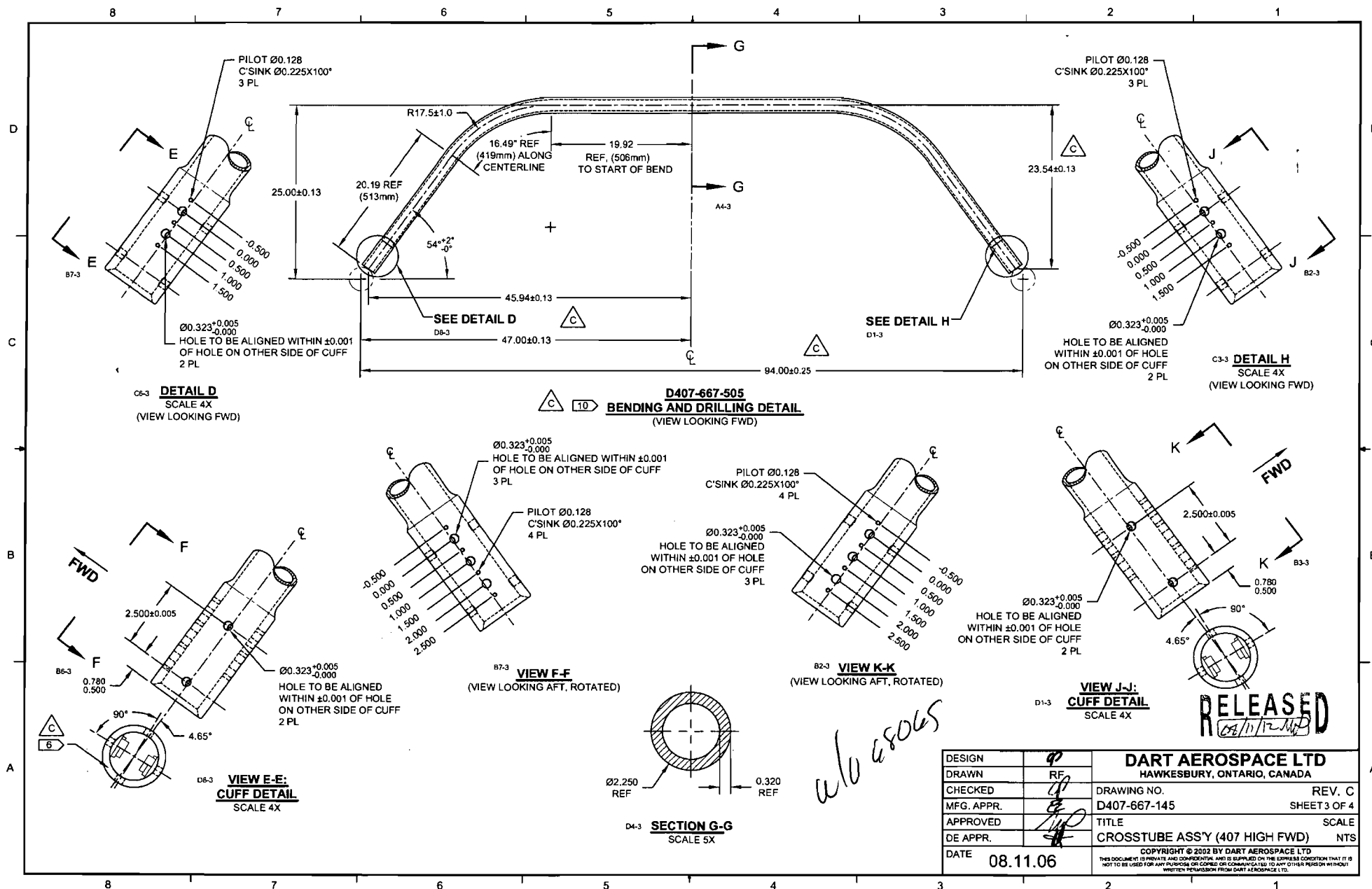
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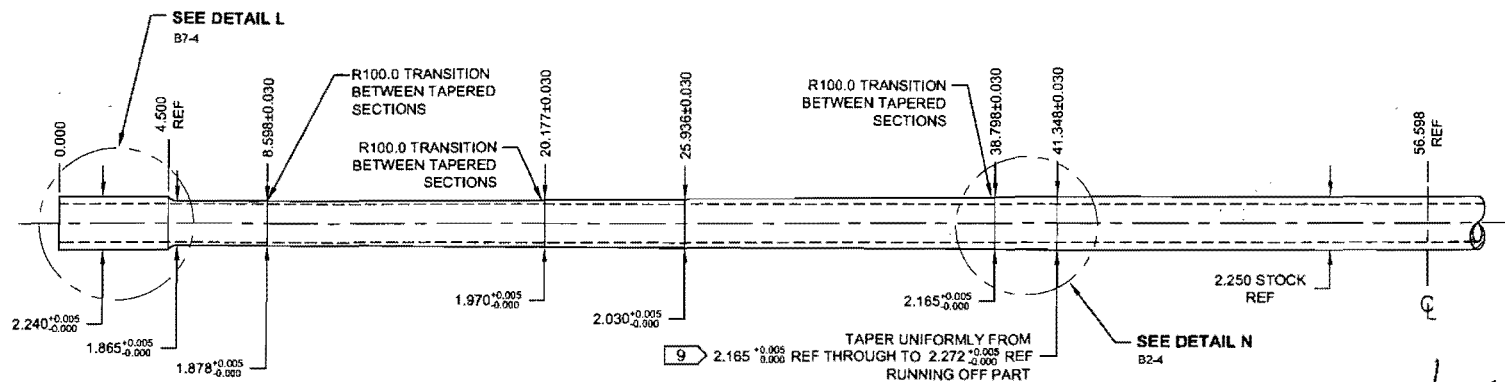
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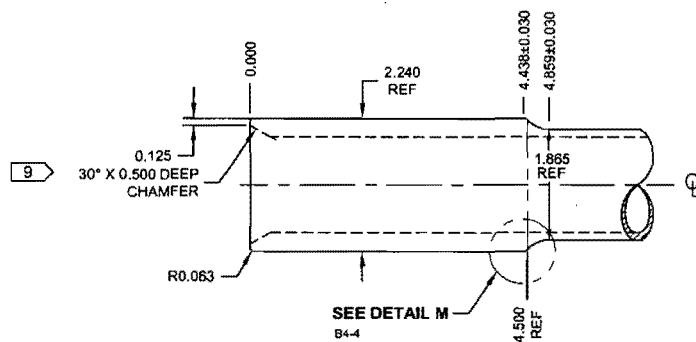
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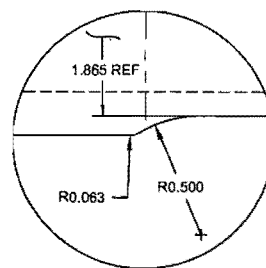


u/b 68065

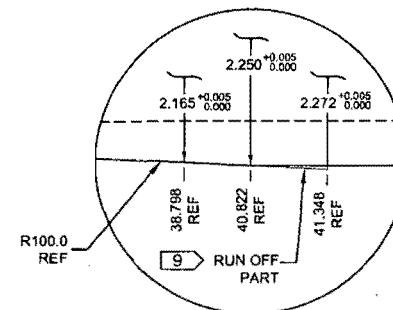
### C TURNING DETAIL



**DETAIL L:  
CROSSTUBE CUFF**  
NOT TO SCALE



**DETAIL M:  
CUFF TRANSITION**  
NOT TO SCALE



**DETAIL N:  
TAPER RUN-OFF**  
NOT TO SCALE

**RELEASED**  
08/11/06

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